

Date: Monday, 09/03/2009 3:29:38 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: RIB		
<b>Job Number</b>	: 46366			<b>Part Number</b>	: D22217		
<b>Estimate Number</b>	: 13675			<b>Drawing Number</b>	: D2221 REV H (PG.5)		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 09/03/2009	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: H		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: //	<b>Type</b>	: LARGE FAB ASSY	<b>Due Date</b>	: 13/03/2009		
<b>Previous Run</b>	: 46083			<b>Qty:</b>	4	<b>Um:</b>	Each
<b>Written By</b>	:			<b>Comment</b>	: Est Rev:A New Issue 08-12-02 DD verified by:EC		
<b>Checked &amp; Approved By</b> : <u>JUL 09.03.09</u>							

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 4.8344 f(s)/Unit Total : 19.3376 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M110969</u>	<u>SAD</u> <u>09-03-13</u> <u>4</u>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1  1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube	<u>SAD</u> <u>09-03-213</u> <u>(4)</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>PS03-13(4)</u>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>BASKET CELL</u>	<u>PS09/03/13</u> <u>(4)</u>
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	<u>D09/03/15</u> <u>(4)</u>
Job Completion			<u>U 09.03.13</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

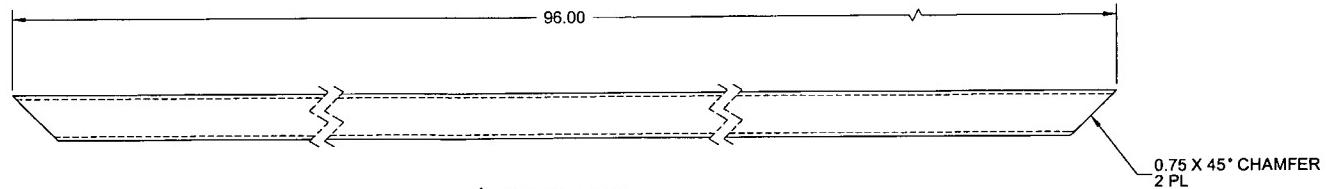
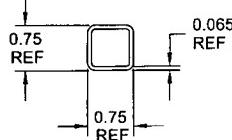
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

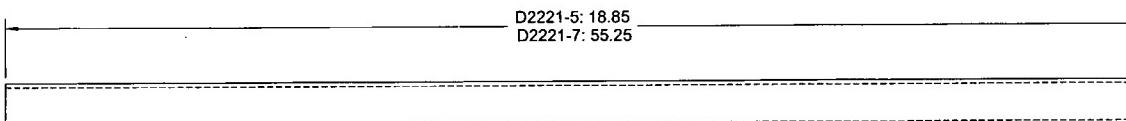
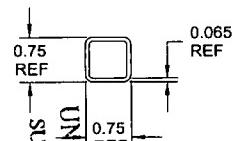
D

D

**D2221-1 RIB**

C

C

**D2221-5-7 RIB**

B

B

NO. W0636c  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY  
 D

- NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

8 7 6 5 4 3 2 1

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
*08/11/18 IND*